DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-008531
Date Inspected: 20-Aug-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	CWI: Ju Jun/Li Lin			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower components

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:
This QA Inspector randomly observed the following work in progress:

SMAW Process:
Non critical repair welding of skin plate & stiffeners located on PCMK NSD1 FCSA4-1 E/E. Welder is identified as 053829. ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G 2(F)-Repair.

Non critical repair welding of skin plate & stiffeners located on PCMK NSD1 FCSA4-1 E/E. Welder is identified as 040268. ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-2G 2(F)-Repair.

Non critical repair welding of stiffeners located on PCMK SSTL3-1 I/K. Welder is identified as 040267. ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345+485-SMAW-2G 2(F)-Repair.

FCAW Process:
Welding of weld Joint# 66 located on PCMK ESTL3-1 C/K. Welder is identified as 066155. ZPMC QC is

identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

Welding of weld Joint# 154 located on PCMK ESTL3-1 C/K. Welder is identified as 048627. ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

Welding of weld Joint# 153 located on PCMK ESTL3-1 C/K. Welder is identified as 068627. ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

SAW Process:
Welding of weld Joint# 1A located on PCMK ED1 A5007-5, 6, 7, 8. Welder is identified as 050295. ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Welding of weld Joint# 1A located on PCMK ED1 A5012-9, 10, 11, 12. Welder is identified as 040489. ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Bay# 11- Tower Assembly:
This QA Inspector randomly observed the following work in progress:

FCAW Process:
Welding of weld Joint# 23,122 located on PCMK ESTL3-4 G/K. Welder is identified as 070212. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 24,123 located on PCMK ESTL3-4 G/K. Welder is identified as 070212. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

Welding of weld Joint# 21,119 located on PCMK ESTL3-4 I/K. Welder is identified as 067184. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 22,120 located on PCMK ESTL3-4 I/K. Welder is identified as 067184. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

Welding of weld Joint# 28 located on PCMK ESTL3-4 D/K. Welder is identified as 066882. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

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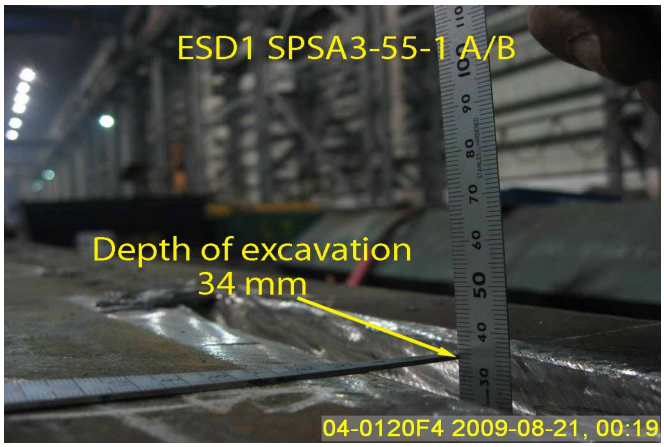
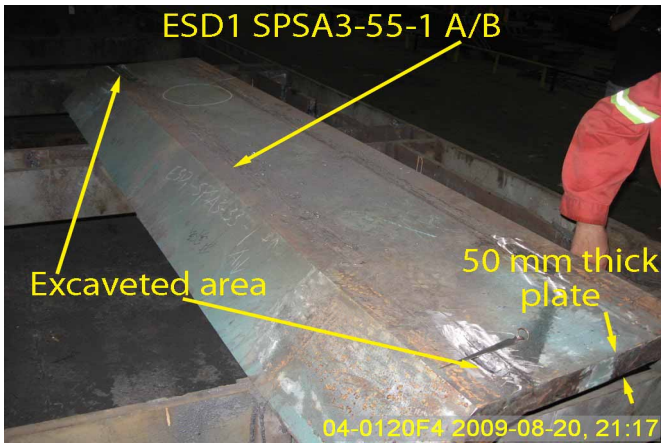
Welding of weld Joint# 28 located on PCMK ESTL3-4 C/K. Welder is identified as 066882. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 29 located on PCMK ESTL3-4 D/K. Welder is identified as 066882. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4333-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.





Summary of Conversations:

Bay# 11- Tower Assembly:

During random Inspection of Tower strut components, it was observed that the areas marked by ZPMC UT operator were excavated by air carbon arc process, for repairing of weld joint# ESD1 SPSA3-55-1 A/B. The depth of excavation was measured approx 34mm to 35mm in some places for the 50mm thick plate which is more than 65% 0f the thinner plate thickness. The matter was notified to the ZPMC QC Chao Cheng for obtaining Engineer's approval in the form of Critical Weld Repair (CWR), before carrying out any repair.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer